



Dart Aerospace Ltd.
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D2572**Job Sheet 195087****Part No:** D2572**Job Qty:** 1 pcs**Part Name:** Saddle, Fwd, In**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/14/19**Job Tracking No:****Due Date:** 5/17/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	1 pcs	5/17/19		0.00	0.00	HAAS - 1		VH8 19/5/15
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	1 pcs	5/17/19		0.00	1.61	HAAS - 1 - B4B		VH8 19/5/15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	1 pcs	5/17/19		0.00	0.16	Conventional Mill - 1 - B4B		VH8 19/5/15
							Conventional Mill - 2 - B4B		
120	QC 2	1 pcs	5/17/19		0.00	0.00	QC 2 - 1		VH8 19/5/15
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

**Container No:** S181487**Part:** D2572**Job No:** 195087**Serial No/Batch:** S181487**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 05/15/19

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				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130	QC 8	1 pcs	5/17/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
140	Handfinish - 1-1 Chemical-B4B	1 pcs	5/17/19	0.00 0.04	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	Powdercoat - 1 White Gl(A)-	1	5/17/19	0.00 0.04	Powdercoat - 1 - B4B

QC 8 - 49

MAY 22 2019

B4B M161749		pcs			Powdercoat - 2 - B4B	
START: 2.15 OUT: 3.30 FINISH: 2.45					Powdercoat - 3 - B4B	BL 19-5-22
160 QC 3		1	5/17/19	0.00 0.00	Powdercoat - 4 - B4B	
		pcs			QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	DAS MAY 22 2019 40
					QC 3 - 19	9-89
					QC 3 - 43	
					QC 3 - 24	
170 Packaging 3-1 - Stock - B4B		1	5/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	

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				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	5/17/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (HAAS CNC vertical machine #1) Program Batch No. <u>518487</u> Double check by: _____ 1-Machine Step No 1 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp 110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-005	Saddle Billet	1 pcs (1 ea)	90-Machining - Issue SN	<u>5166696</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-005	1	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Inboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Inboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Inboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Inboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Inboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Inboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Inboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Inboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Inboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Inboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Inboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Fwd Inboard	3.869Inches + 0.010 - 0.000	3.879 3.869		
16	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Fwd Inboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Fwd Inboard	0.240Inches + 0.020 - 0.000	0.260 0.240		
19	Saddle, Fwd Inboard	0.115Inches + 0.020	0.135		

			- 0.000	0.115
20	Saddle, Fwd Inboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Fwd Inboard	2.940Inches	+ 0.040 - 0.000	2.980 2.940
22	Saddle, Fwd Inboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Fwd Inboard	0.307Inches	+ 0.005 - 0.000	0.312 0.307
25	Saddle, Fwd Inboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Fwd Inboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Fwd Inboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Fwd Inboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Fwd Inboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Fwd Inboard	1.375Inches	+ 0.020 - 0.000	1.395 1.375
32	Saddle, Fwd Inboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Fwd Inboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Fwd Inboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Fwd Inboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Fwd Inboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 191087
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.000					
F	0.490	0.510		0.497					
G	0.257	0.262		0.258					
H	0.375	0.380		0.375					
I	0.490	0.510		0.500					
J	1.174	1.184		1.179					
K	0.558	0.578		0.568					
L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.874					
P	0.115	0.135		0.129					
Q	0.115	0.135		0.115					
R	0.240	0.260		0.254					
S	0.115	0.135		0.129					
T	0.178	0.198		0.188					
U	2.940	2.980		2.960					
V	0.230	0.250		0.238					
W	0.115	0.135		0.135					
X	0.307	0.312		0.311					
Y	0.760	0.765		0.760					
Z	0.352	0.372		0.363					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.623					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.248					
AE	1.375	1.395		1.385					
AF	0.115	0.135		0.130					
AG	0.240	0.280		0.250					
AH	0.240	0.260		0.255					
AI	2.000	2.020		2.000					
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by:	VHJ
Date:	19/5/15

Audited by:	AMK
Date:	19/05/21

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	